

Work Order ID 79742***79742***

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February 1, 2012 10:34:32 AM

Item ID: D6014-090 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: ALUMINUM EXTRUSION
Start Date: 2/01/12 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 2/01/12 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: C2 Date: 12/02/01 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D6014	Rev A								

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 16064

a) Extrude as per Dwg D6014

b) Material: 7075-T73/T73510/T73511 (QQ-A-200/11) Seamless Aluminum Tube

c) Minimum ultimate tensile strength = 68 ksi

d) Minimum tensile yield strength = 57 ksi

Possible Supplier: Aluminum Works

Mater

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

u 12-01-0216489 (49)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79742

79742

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February 1, 2012 10:34:32 AM

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 Required Date: 2/01/12 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo Ensure Material certification comply to Dwg D6006	0.00 0.00	S216109 see last page for inspect Report.						
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>landing GEAR</u> Memo	0.00 0.00							<u>12-5-9</u>
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>12/5/10</u> <u>MF</u> <u>12-05-09</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 1, 2012 10:34:31 AM

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Work Order ID: 79742

Parent Item: D6014-090

Parent Item Name: ALUMINUM EXTRUSION

Start Date: 2/01/12

Required Date: 2/01/12

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A05.08.31New issueKJ/JLM
and qc3

IPP Rev:B 10.06.07 remove handfinishing

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090P ALUMINUM EXTRUSION		Purchased	No			110	Each	0.0000	1	50		2/1/12	(42)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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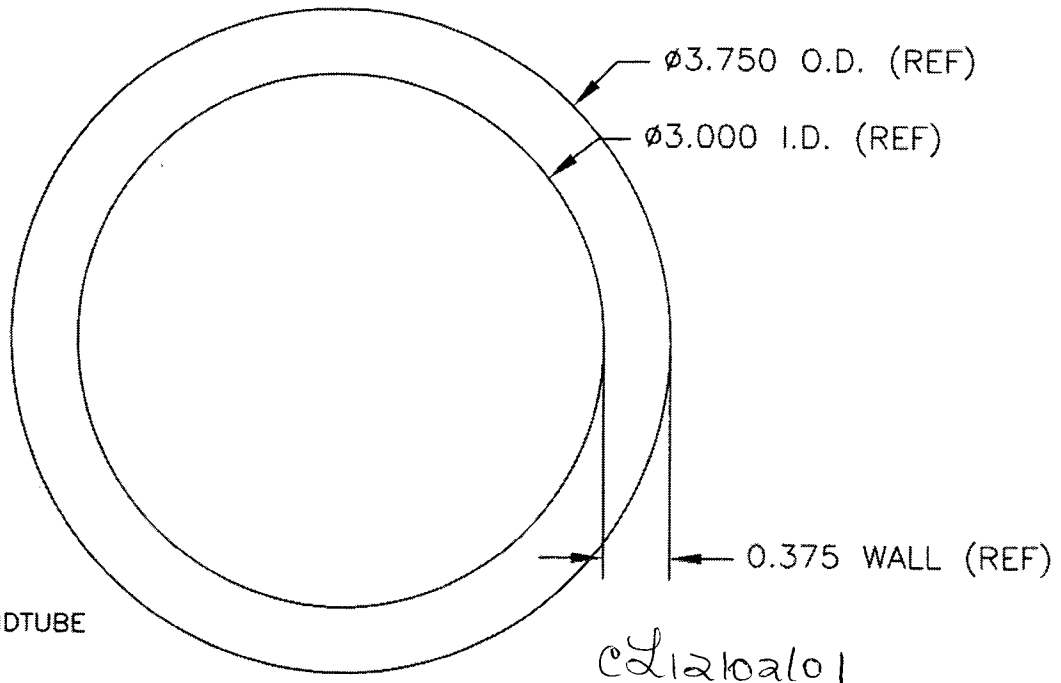
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6014	REV. A SHEET 1 OF 1
DATE 05.03.18		TITLE SKIDTUBE MATERIAL	SCALE 1:1
A	05.03.18	NEW ISSUE	

RELEASED
05-08-09 *[Signature]*

SPECIFICATION CONTROL DRAWING



NOTES

- 1) D6014-XXX SKIDTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 64" LONG TUBE: D6014-064

- 2) MATERIAL: 3.750 OD x 0.375 WALL 7075-T73/T73510/T73511 PER QQ-A-200/11
SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 68 ksi
MINIMUM YIELD TENSILE STRENGTH = 57 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.015 MEAN (± 0.038 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.188/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Al. Unna ref. no.	45817/100
Customer PO.	Po. 16064
Date:	03.30.12

Dart Aerospace P.O. 16064
D6014-090
Made in Germany Dest.: Hawkesbury ONT, Canada

free from live plant pests

S:\VERSAND\USA_Packliste\45817_100

2

4

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1

[illegible]

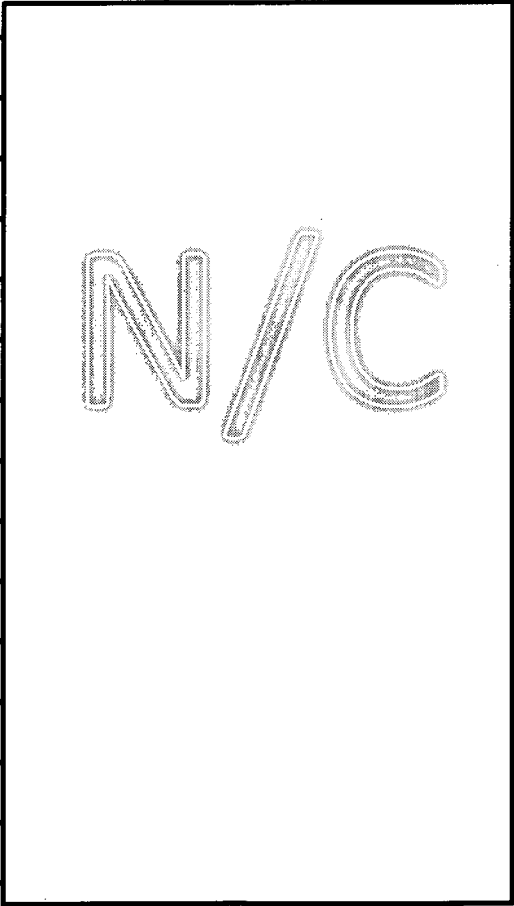
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Section 809

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EXTRUSION INSPECTION SHEET

ULTRA SONIC MEASUREMENTS

TUBE #	TOTAL LENGTH	DIA two readings	INSIDE DIA	wall thickness measured w/vern	Strightness at 12"	Rockwell Reading	LOCATION on tube	R1	R2	R3	R4
DWG	90.000"	30750"	3.000"	0.375"	N/C	N/C					
1	90.000"	3.754"/3.756"	2.991"	0.383"/0.379"	N/C	N/C					
2	90.000"	3.752"/3.751"	2.990"	0.378"/0.381"	N/C	N/C					
3	90.000"	3.751"/3.749"	2.987"	0.378"/0.380"	N/C	N/C					
4	90.000"	3.756"/3.751"	2.993"	0.377"/0.380"	N/C	N/C					
5	90.000"	3.755"/3.750"	2.989"	0.379"/0.381"	N/C	N/C					
6	90.000"	3.749"/3.7751"	2.990"	0.381"/0.382"	N/C	N/C					
7	90.000"	3.756"/3.751"	2.990"	0.380"/0.386"	N/C	N/C					
8	90.000"	3.751"/3.751"	2.993"	0.378"/0.382"	N/C	N/C					
9	90.000"	3.752"/3.750"	2.989"	0.377"/0.385"	N/C	N/C					
10	90.000"	3.749"/3.749"	2.995"	0.380"/0.384"	N/C	N/C					
11	90.000"	3.751"/3.750"	2.991"	0.379"/0.381"	N/C	N/C					
12	90.000"	3.752"/3.752"	2.991"	0.379"/0.380"	N/C	N/C					
13	90.000"	3.750"/3.751"	2.993"	0.379"/0.381"	N/C	N/C					
14	90.000"	3.752"/3.750"	2.994"	0.381"/0.380"	N/C	N/C					
15	90.000"	3.749"/3.748"	2.990"	0.382"/0.386"	N/C	N/C					
PART # D6014-090		P/O# 16064		BATCH # B79742		Notes:					

REFERENCE ONLY

Diston